



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D5510-041
Job Sheet 187690



Part No: D5510-041

Job Qty: 4 pcs

Part Name: Fwd Step Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/11/18

Job Tracking No:

Due Date: 12/28/18

Created By: Marie Lajeunesse

Type: ~~SOLD~~ *SHK*

Description:

Note: DWG SHEET 1 IPP REV:A 17.03.28 NEW ISSUE DD VERF:RQ

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Large Fab - Steps - 1	4 pcs	12/28/18		0.00	0.00	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		<i>ll</i>
							Large Fab - 8		
120	QC 9	4 pcs	12/28/18		0.00	0.00	QC 9 - 10		
							QC 9 - 18		
							QC 9 - 24		
							QC 9 - 43		<i>DAS 43</i>
							QC 9 - 50		<i>9-39</i>
							QC 9 - 9		
130	QC 5	4 pcs	12/28/18		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 38		
							QC 5 - 42		<i>DAS</i>
							QC 5 - 43		<i>43</i>
							QC 5 - 49		<i>9-39</i>
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		



Container No: S189430



Part: D5510-041

Job No: 187690

Serial No/Batch: S189430

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 06/12/19

140 Handfinish - 1-1 Chemical-B4B	4 pcs	12/28/18	0.00 0.00	QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	 JUN 12 2019
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
150 QC 7	4 pcs	12/28/18	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 38	
				QC 7 - 41	

				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	BEB 19/06/12
				QC 7 - 6	
				QC 7 - 60	
				QC 7 - 9	
				QC 7 - 68	
				QC 7 - 50	
				QC 7 - 67	
160 Powdercoat - 1 White Gl(A)- B4B M 135454	4 pcs	12/28/18	0.00 0.00	Powdercoat - 1 - B4B	
				Powdercoat - 2 - B4B	
				Powdercoat - 3 - B4B	BK 19-6-12
				Powdercoat - 4 - B4B	
170 Handfinish - 3-1- WingWalk- B4B	4 pcs	12/28/18	0.00 0.00	Handfinish - 3 - 1 - B4B	W 14-6-12
				Handfinish - 3 - 2 - B4B	
				Handfinish - 3 - 3 - B4B	
				Handfinish - 3 - 4 - B4B	
				Handfinish - 3 - 5 - B4B	
180 QC 3	4 pcs	12/28/18	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 26	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 38	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 6	
				QC 3 - 68	
				QC 3 - 9	
190 Packaging 3-1 - Stock - B4B	4 pcs	12/28/18	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	

				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
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				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	PC ST 534
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
Packaging 3 - 36 - B4B					
200 QC 21 - SA	4	12/28/18	0.00 0.00	QC 21 - SA - 21	DAS
	pcs			QC 21 - SA - 70	21 JUN 17 2019

Part Op **110** - Weld per dwg A/R Aluminum rod Batch: _____

Descriptions: **120** - QC9- Inspect visual per QSI004- Fusion Welds

130 - QC5- Inspect part completeness to step on W/O

140 - Chemical Conversion Coat per QSI005 4.1

150 - QC7-Inspect Chemical Conversion Coat

160 - White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum START TIME: _____ OVEN TEMPERATURE: _____

FINISH TIME: _____

170 - Wing Walk as per dwg QSI005 4.4 Batch _____

180 - QC3- Inspect Part Finish

190 - Identify as per dwg & Stock Location: _____

200 - QC21- Final Inspection - Work Order Release

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
D5510-1	Fwd Step	4 pcs (1 ea)	110-Large Fab - Steps - 1	5010343
D5510-3	Gusset	8 pcs (2 ea)	110-Large Fab - Steps - 1	5009531

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Large Fab - Steps - 1	D5510-1	4	4	0
	D5510-3	8	8	0

Part Specifications	
Specifications could not be found.	

Plex 1/25/19 11:24 AM Dart.Hadley.Shannon

010308



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Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea		12/28/18	0.00	0.00	Start Up Large Fab-3		
110	Large Fab	2 pcs		12/28/18	0.00	0.00	Large Fab 2		
120	QC	2 pcs		12/28/18	0.00	0.00	QC9		
130	QC	2 pcs		12/28/18	0.00	0.00	QC5		
140	HandFinish	2 pcs		12/28/18	0.00	0.00	HandFinish1		
150	QC	2 pcs		12/28/18	0.00	0.00	QC7-5		
160	Powdercoat	2 pcs		12/28/18	0.00	0.00	Powdercoat1		
170	HandFinish	2 pcs		12/28/18	0.00	0.00	HandFinish3		
180	QC	2 pcs		12/28/18	0.00	0.00	QC3		
190	Packaging	2 pcs		12/28/18	0.00	0.00	Packaging3-2		
200	QC21-SA	2 Ea		12/28/18	0.00	0.00	QC21		

Part Op Descriptions: 160 - START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D5510-1	Fwd Step	2 Ea (1 ea)	90-Start up Operation	
D5510-3	Gusset	4 Ea (2 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D5510-1	2	4	0
	D5510-3	4	8	0

Part Specifications

Specifications could not be found.

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Eng. (Non-AW) ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Water Jet ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Supplier Quality ☐</td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Eng. (Non-AW) ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Water Jet ☐	Large Fab ☐	Finishing ☐	Rec/Store/Packaging ☐	Supplier Quality ☐																																
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Date :	Sequence #:	QTY Affected :		MRB (QSI042)																																													
Description Work Order Deviation			Disposition																																														
			Completed By																																														
			Lead hand / Supervisor																																														
			QC / QA Coordinator																																														
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